



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4635-3

Job Sheet 185089



Part No: D4635-3

Job Qty: 1 ea

Part Name: Aft Ceiling Panel, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F SHEETS 15,17,18 IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg.
Update 12/11/08 DL IPP Rev C Dwg. Uupdate 13/07/09 DL IPP Rev. D Dwg. Update, Material Change
13/12/18 DL IPP Rev. E Dwg. Update 14/01/09 DL IPP Rev F Dwg. update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	4 pcs	5/18	11/23/18	0.00	0.00	Purchasing		NOV 22 2018
140	Packaging	4 pcs		11/23/18	0.00	0.00	Packaging2		NOV 22 2018
150	QC	4 pcs		11/23/18	0.00	0.00	QC6		61
170	Packaging	4 pcs		11/23/18	0.00	0.00	Packaging3	16 234	NOV 27 2018 9-89
180	QC21-SA	4 Ea		11/23/18	0.00	0.00	QC21		6

Part Op 140 - Receive & Inspect for Damage & Mat'l Certs
Descriptions: 150 - QC6- All purchased or subcontracted products
170 - Identify as per dwg & Stock Location:
180 - QC21- Final Inspection - Work Order Release

PO 041442 oct 24, 2018 - 4 Pch

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4635-3P	Aft Ceiling Panel, LH	4 pcs (1 ea)	110-Purchasing	5130768
MLEXS.093-F6006-07	GE Plastics Lexan Sheet (Light Grey)	37.5600 sf (9.39 ea)	110-Purchasing	5130769

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D4635-3P	4	0	0
	MLEXS.093-F6006-07	38	1,735	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

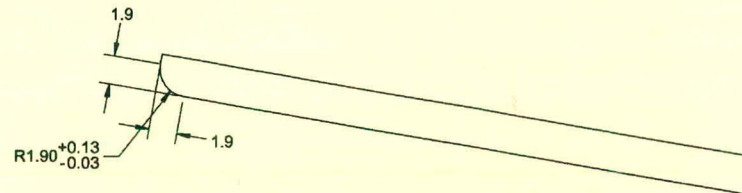
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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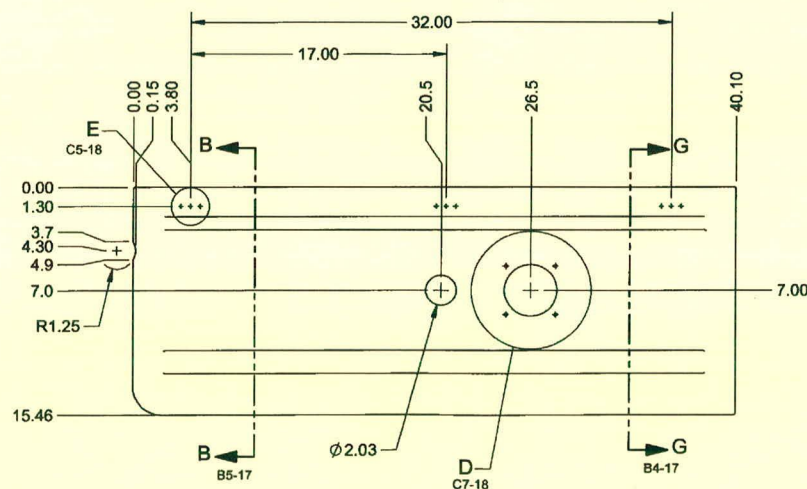
Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause		FAULT CATEGORY	
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Ur ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/ Drill Holes ☐
OTHER :		Power Loss/Surge ☐ Folio/Program ☐	Positioned Wrong ☐ Outside Dimensions ☐

DART AEROSPACE
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 613 602-6200
 Email: sales@dartaero.com
 www.dartaerospace.com
 Date: 11/22/18
 Instructions: Various STCs
 Exp Date:
 Inspection:
 Revision:
 Serial No/ Batch: S130770
 Job No: 185089
 Part: D4635-3
 Container No: S130770



SECTION H-H B2-15

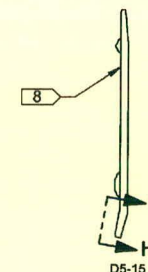


D4635-3 LH, AFT CEILING PANEL

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.66 lbs
 - 8) TEXTURE ON THIS SIDE
 - 9) TRIM D4635-3 PER TOOL DT9841
 - 10) THERMOFORM D4635-3 PER QSI 022 USING DT9849 TOOL
- MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

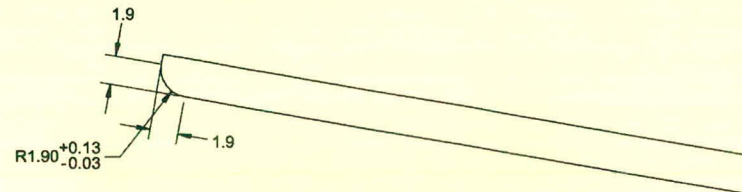
SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185089 MWS
18-1022



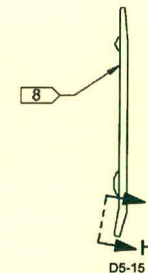
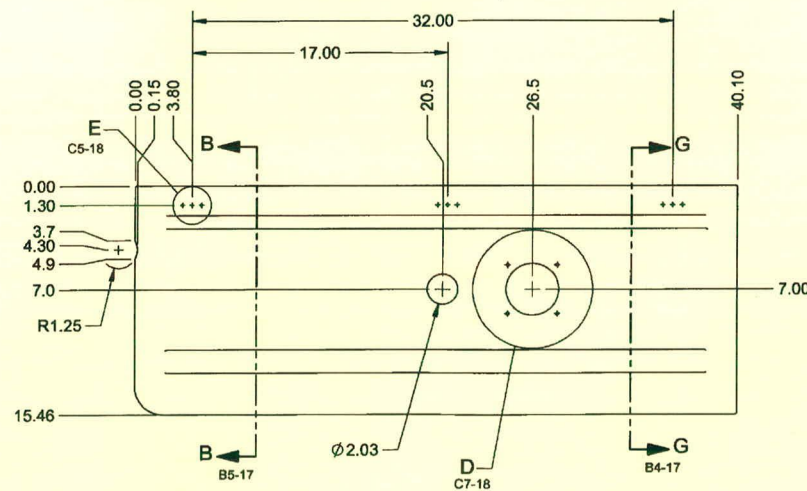
RELEASED
2015 JAN 26

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO. D4635	REV. F
MFG. APPR.	DL		SHEET 15 OF 18
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD CEILING PANELS	NTS
DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION H-H B2-15



D4635-3 LH. AFT CEILING PANEL

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.66 lbs
 - 8) TEXTURE ON THIS SIDE
 - 9) TRIM D4635-3 PER TOOL DT9841
 - 10) THERMOFORM D4635-3 PER QSI 022 USING DT9849 TOOL
- MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

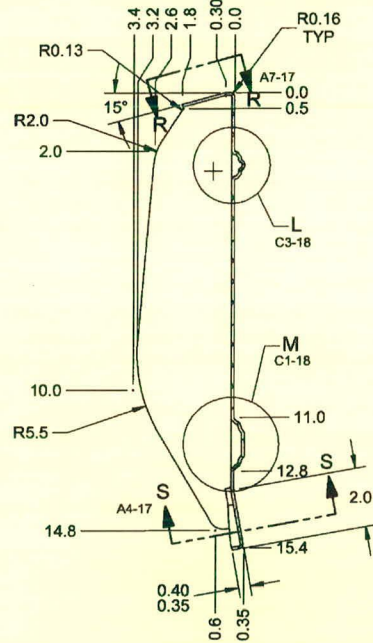
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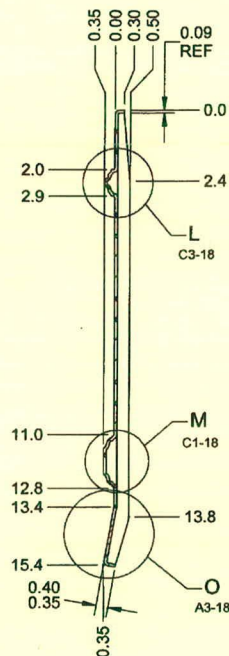
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MFG. APPR.	DL	SHEET 15 OF 18	
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DE APPR.	DS	OUTBOARD CEILING PANELS	
DATE	14.11.28	NTS	

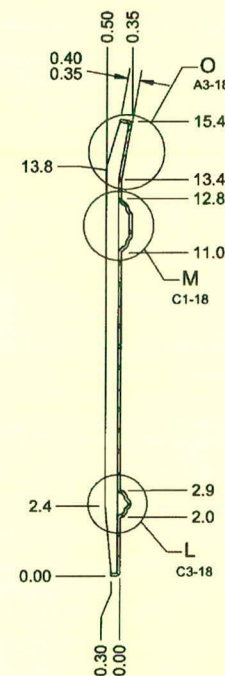
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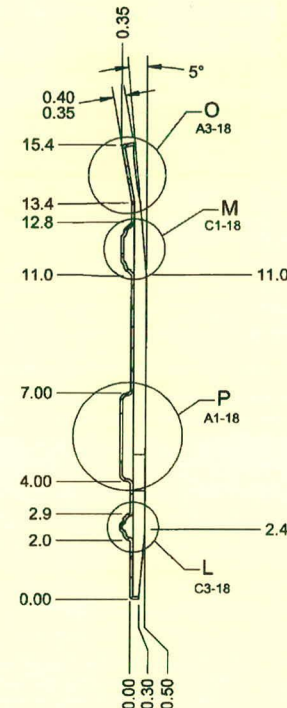
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SECTION A-A' OPPOSITE
SCALE 2X



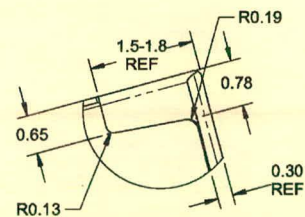
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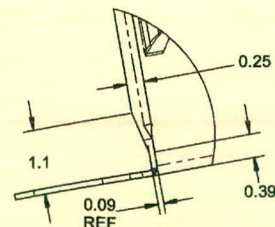
SECTION G-G
SCALE 2X



SECTION K-K
SCALE 2X



AUXILIARY VIEW R-R
SECTION R-R' OPPOSITE
SCALE 2X



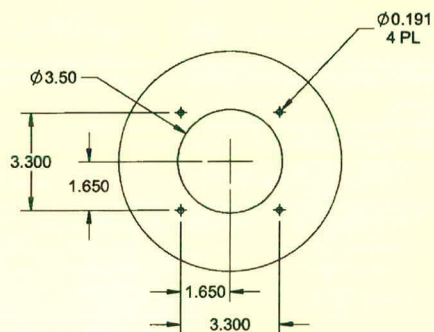
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SECTION S-S' OPPOSITE
SCALE 2X

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2015 JAN 26

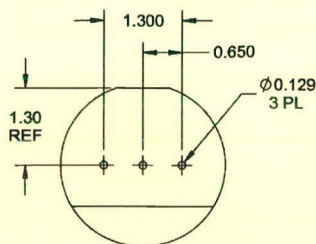
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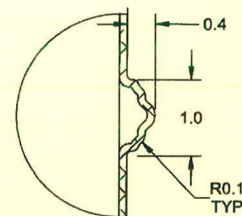
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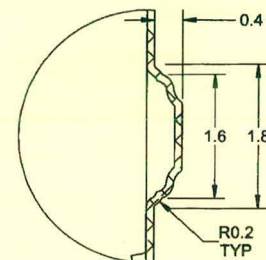
DETAIL D
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B4-13
B3-14
B5-15
B5-16



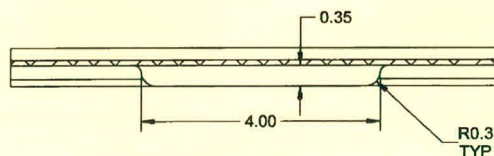
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B5-16



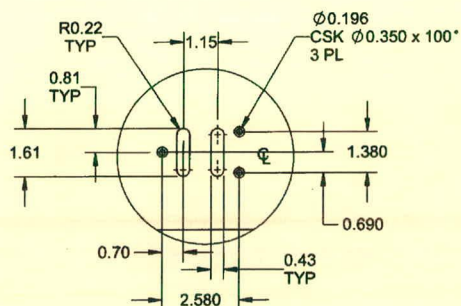
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B2-17
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C5-17
C7-17



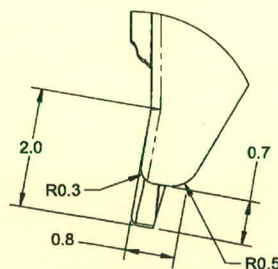
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C5-17
C7-17



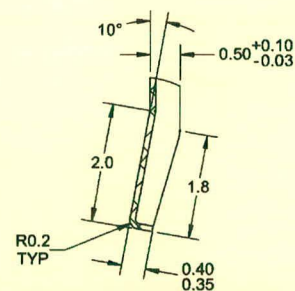
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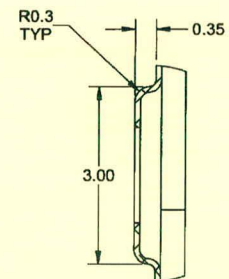
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SCALE 2X
C5-16



DETAIL N
SCALE 2X
B2-13



DETAIL O
SCALE 2X
D2-17
D3-17
B5-17



DETAIL P
SCALE 4X
C2-17

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2015 JAN 26

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	DL	D4635	SHEET 18 OF 18
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD CEILING PANELS	NTS
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8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041442**

Supplier: PLA002-VC
Plas-Tech
115 Applewood Crescent
Concord
ON
L4K 5C1 Canada
Phone: 416-736-0004
Fax: 416-736-0010

PO No: PO041442
PO Date: 10/24/18
Due Date: 11/21/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lussier, Patrick Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Revision

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185086	D4635-1P			Fwd Ceiling Panel, LH : Various STC's As Per Dwg D4635 Rev. F	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00
2	185089	D4635-3P			Aft Ceiling Panel, LH : Various STC's As Per Dwg D4635 Rev. F	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00
3	185093	D4635-2P			Fwd Ceiling Panel, RH : Various STC's As per Dwg D4635 Rev. F	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00
4	185094	D4634-1P			Fwd, Center Ceiling Panel : Various STC's As Per DWG D4634 REV. G	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00
5	185099	D4634-3P			Middle, Center Ceiling Panel : Various STC's As Per Dwg D4634 Rev G	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00
6	185101	D4634-5P			Aft, Center Ceiling Panel : Various STC's As Per Dwg D4634-5 Rev. G	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00
7	185823	D4635-4P			Aft Ceiling Panel, RH : Various STC's As Per Dwg D4635 Rev. F	Firmed	-	11/21/18	5 pcs	0 pcs	5 pcs	\$225.00/pcs	\$1,125.00

Grand Total: \$7,875.00

Plex 11/2/18 2:35 PM dart.Lussier.Patrick



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO041442

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

A handwritten signature in black ink, appearing to be "PL", located on the right side of the Order Notes section.

Plex 11/2/18 2:35 PM dart.Lussier.Patrick



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Packing Slip

Shipment Number: 32499
Shipment Date: 11/21/2018
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: DALE BATES
O Buyer Contact: PATRICK LUSSIER

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: PATRICK LUSSIER
O

Purchase Order
41442

Sales Order
SO-026069

Incoterms
EX WORKS

Payment Method
COL

Carrier Account #
151793240

Ship Via
FEDERAL EXPRESS - Priority Overnight

Tracking Number
773784773870

Item Number
Revision
D4635-3 Rev. F

Description
AFT CEILING PANEL, LH
AS PER DWG D4635 REV. F

DAS
61
9-89

Quantity
Shipped
5 EA

Number of Containers

Gross Weight

Shipped By

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 41442 ✓ SO # 026069

DAS

61

9-89

Part #	<u>4635-3</u> ✓	Qty.	<u>5</u> ✓	Batch #	<u>-003</u>
Description	<u>AFT CEILING PANEL, L.H.</u>	Material usage	<u>OFF CUT</u>	Lot#	<u>DART0116</u>
					<u>0007424014</u>
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
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Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: AB
(Approved QA Signatory)

Date: Nov. 21, 2018 C OF C # 090

Page: 1 of 1

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com

